

Date: Tuesday, 7/1/2008 2:34:29 PM
User: Kim Johnston

Process Sheet

Rush! As Ap

Split

Customer	CU-DAR001	Dart Helicopters Services	Drawing Name	WEARPAD
Job Number	40191		Part Number	D356411
Estimate Number	12785		Drawing Number	D3564 REV D
P.O. Number			Project Number	N/A
This Issue	7/1/2008	S.O. No. :	Drawing Revision	D
Prsht Rev.	NC		Material	
First Issue	/ /	Type : SMALL /MED FAB	Due Date	7/16/2008
Previous Run	39133		Qty:	20
Written By			Um:	Each
Checked & Approved By	<i>John 07.01</i>			
Comment	Est Rev:A New Issue 07-03-08 ec Est Rev:B As per Rev C 07-07-09 JLM Est Rev:C As per Rev D 07-09-09 JLM Verified By:EC			

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M304S16GA 304/316 .063 Sheet



Comment: Qty: 1.4805 sf(s)/Unit Total: 29.6100 sf(s)

M304S16GA Stainless steel sheet 0.063" thick

Batch: *108156* *FB 8-7-14*

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3564 *****(D3564-1F)*****

Dwg Rev: *D* *FB 8-7-14*Prog Rev: *D*
22
2-Deburr if necessary *FB 8-7-14*

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE


FB 8-7-14

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK


5 08/07/14 422

Comment: SECOND CHECK

5.0 BRAKE NC NC BRAKE



Comment: NC BRAKE

Deburr if necessary

Form on Brake as per Dwg D3564 using Jigs DT *817A* and DT *8155*
803 08/07/14
22

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 7/1/2008 2:34:29 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPAD

Job Number: 40191

Part Number: D356411

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0 QC5



INSPECT WORK TO CURRENT STEP



S 08/07/14 (X22) *cont'd*

Comment: INSPECT WORK TO CURRENT STEP

Ensure joggle as per dwg D3429

7.0 LARGE FAB 1



LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Qty	Description	Batch
A/R	2059B Hardcoat	<u>M107962</u>
Weld hardcoat as per Dwg D3437		

P 08-07-15

EL 8-7-15 (8)

8.0 QC10



VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS

S 08/07/15 (8)

9.0 QC5



INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/07/15 (8)

10.0 POWDER COATING



POWDER COATING



M106442

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

START TIME:

2:45pm

OVEN TEMPERATURE: 320°F

FINISH TIME: 3:15pm

8/1 08-07-15

X9
CIX

11.0 QC3



INSPECT POWDER COAT/CHEMICAL CONVERSION



M.E 08/07/15

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

12.0 PACKAGING 1



PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: FP-19

ME

08-07-15

X9

W/I/O:

WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 7/1/2008 2:34:29 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPAD

Job Number: 40191

Part Number: D356411

Job Number:



Seq. #: Machine Or Operation:

Description :

13.0 QC21

FINAL INSPECTION/W/O RELEASE



08/07/16 HJ

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-07-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

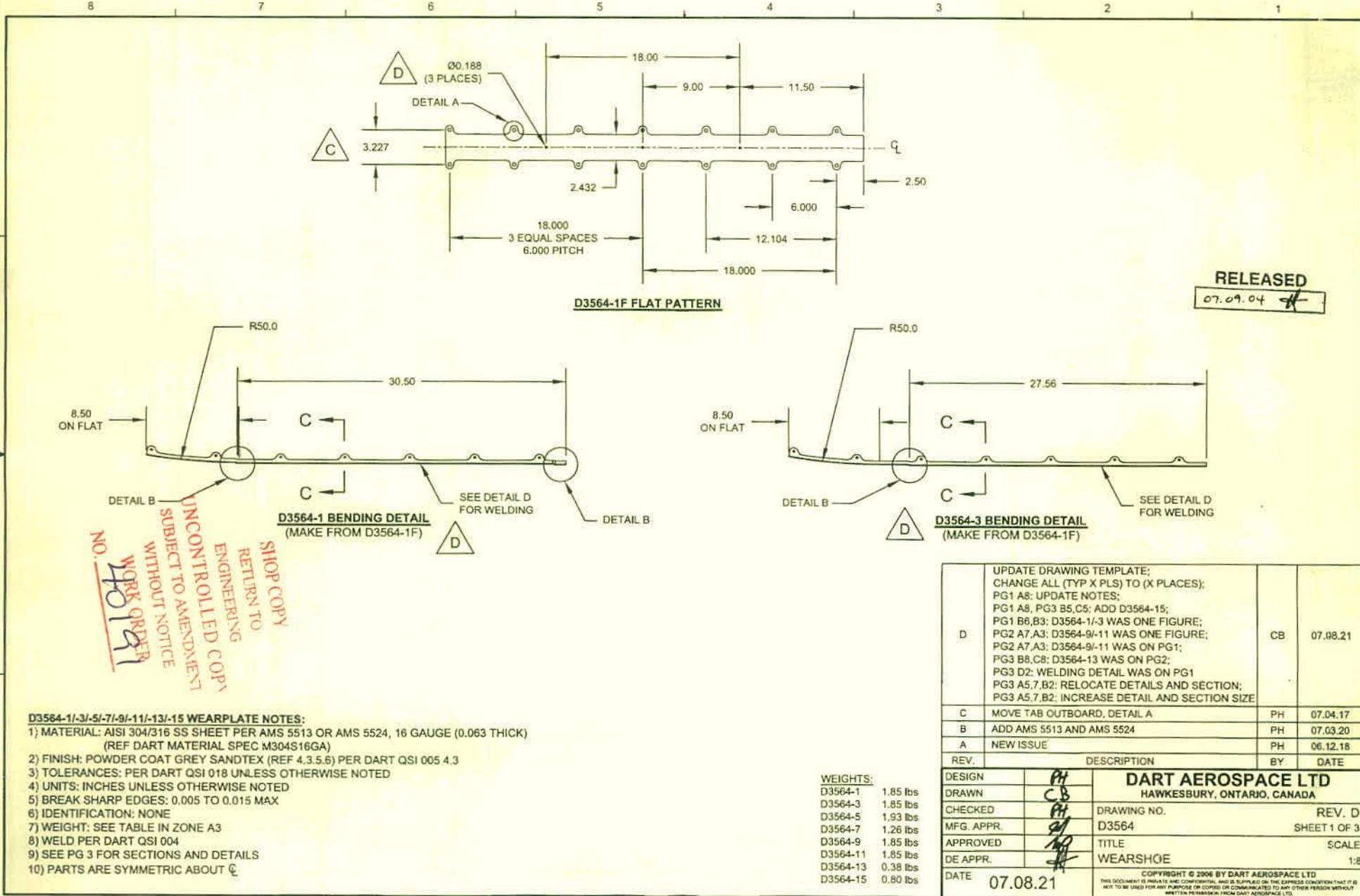
DART AEROSPACE LTD	Work Order:	40191
Description: Wearshoe	Part Number:	D3564-11
Inspection Dwg: D3564	Rev: D	Page 1 of 1

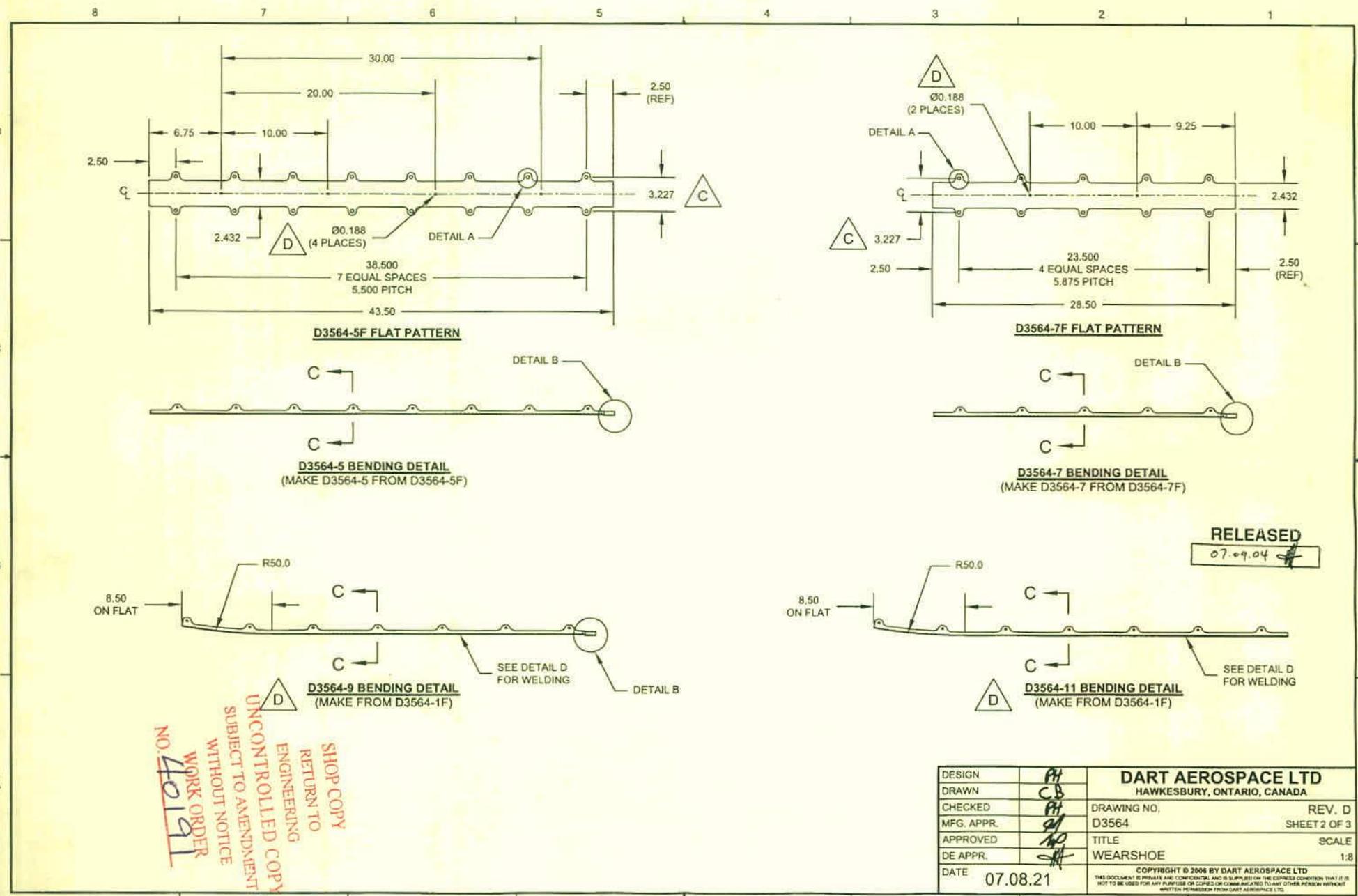
FIRST ARTICLE INSPECTION CHECKLIST

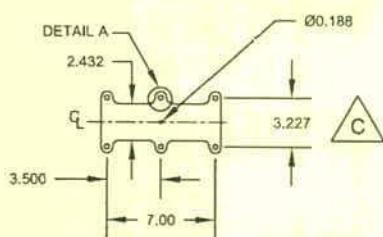
X First Article Prototype

Measured by:	HB	Audited by:	S	Prototype Approval:	N/A
Date:	8-7-14	Date:	8/07/14	Date:	N/A

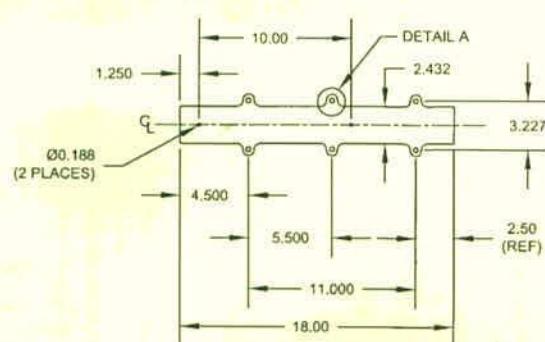
Rev	Date	Change	Revised by	Approved
A	07.09.06	New Issue	KJ/JLM	
B	07.11.23	Dwg Rev updated	KJ/EC/DD	



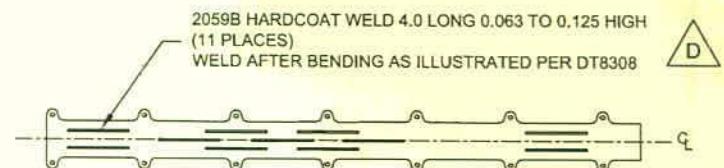




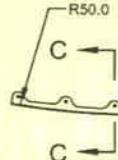
D3564-13F FLAT PATTERN



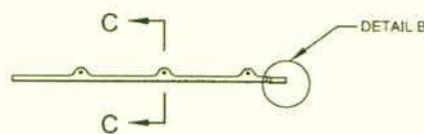
D3564-15F FLAT PATTERN



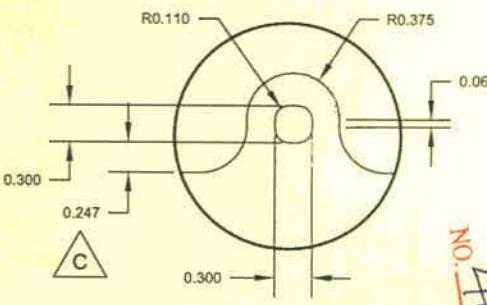
DETAIL D



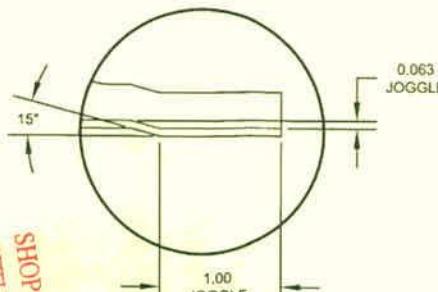
D3564-13 BENDING DETAIL
(MAKE D3564-13 FROM D3564-13F)



D3564-15 BENDING DETAIL
(MAKE D3564-15 FROM D3564-15F)



DETAIL A
SCALE 1:1



DETAIL B
SCALE 1:1

NO. 40141
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
RETURN TO
ENGINEERING
SHOP CO.

DESIGN	PH	DART AEROSPACE LTD	
DRAWN	CB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO.	REV. D
MFG. APPR.	SD	D3564	SHEET 3 OF 5
APPROVED	SD	TITLE	SCALE
DE APPR.	SD	WEARSHOE	1:
DATE	07.08.21	COPYRIGHT © 2006 BY DART AEROSPACE LTD. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED UPON THE EXPRESS CONDITION THAT IT NOT BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE WRITTEN CONSENT OF DART AEROSPACE LTD.	

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W. T. H. - 1914

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